



Dart Aerospace Ltd.
1270 Aberdeen St
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Canada

Tel (613) 632-5200

D3065-7
Job Sheet 178561



Part No: D3065-7

Job Qty: 40 ea

Part Name: Step Spacer



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/1/18

Job Tracking No:

Due Date: 6/22/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP: C 02.11.01 Incorporated D3066-1 IPP KJ/RF IPP Rev:D Now on Water Jet 06-04-11 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	40 Ea		6/22/18	0.00	0.00	Start Up Waterjet		SC 18/06/09
100	Waterjet	40 pcs		6/22/18	0.00	1.47	Waterjet1		SC 18/06/09
120	QC	40 pcs		6/22/18	0.00	0.00	QC8		SC 18/06/09
140	Brake NC	40 pcs		6/22/18	0.02	1.23	Brake NC 1		SC 18/06/09
150	QC	40 pcs		6/22/18	0.00	0.00	QC5		SC 18/06/09
160	HandFinish	40 pcs		6/22/18	0.00	0.71	HandFinish1		SC 18/06/09
170	QC	40 pcs		6/22/18	0.00	0.00	QC7-2		SC 18/06/09
180	Packaging	40 pcs		6/22/18	0.00	0.00	Packaging3-1		SC 18/06/09
190	QC21-SA	40 Ea		6/22/18	0.00	0.00	QC21		SC 18/06/09

Part Op 100 - 1-Cut as per Dwg D3065

Descriptions: 140 - Bend as per Dwg D3065

180 - LOCATION : GA

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.040	2024-T3 .040 Sheet	6.2960 sf (.1574 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M2024T3S.040	6	171	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Step Spacer	0.128inches + 0.005 - 0.000	0.133 0.128	0.129	
2	Step Spacer	0.865inches ± 0.005	0.870 0.860	0.868	
3	Step Spacer	4.522inches ± 0.010	4.532 4.512	4.525	
4	Step Spacer	0.250inches ± 0.010	0.260 0.240	0.251	
5	Step Spacer	2.093inches ± 0.010	2.103 2.083	2.091	

Work Order update only

AGAINST DEPARTMENT/PROCESS

Water Jet
Prod. Eng. Coord.
Rec/Store/Packaging

Container No: S079484

Part: D3065-7

Job No: 178561

Serial No/Batch: S079484

Revision:

Inspector:

Exp Date:

Instructions:

Supervisor
Verification

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CANADA
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Root Cause

Pressure/Force
Bending
Centre Not Co
Cracks
Crimp/Kink/Rip
Cuffs
Crushing
Heat Treat
Wave/Twist in
Marks/Chatter

OTHER:

6	Step Spacer	3.936inches $\pm$ 0.005	3.941 3.931	3,940
7	Step Spacer	4.186inches $\pm$ 0.010	4.196 4.176	4,190
8	Step Spacer	1.250inches $\pm$ 0.005	1.255 1.245	1,252
9	Step Spacer	0.125inches $\pm$ 0.010	0.135 0.115	0,125
10	Step Spacer	Attribute		

Plex 6/1/18 2:52 PM Dart.lajeunesse.marie

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					